

Date: Wednesday, 7/12/2006 3:23:26 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARPAW KIT (19"X24")		
Job Number	: 27871					
Estimate Number	: 10323					
P.O. Number	: N/A			Part Number	: K10008	
This Issue	: 7/12/2006		S.O. No. : N/A	Drawing Number	: D2432 REV F3	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: F3	
Previous Run	: 27357			Material	: N/A	
Written By	<u>See Comment Below</u>			Due Date	: 7/30/2006	
Checked & Approved By	<u>OK 06.07.12</u>			Qty:	10 Um: Each	
Comment	: Est Rev.J 04.02.17 Blank size changed KJ/JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile: K10008 D206-559-013 D350-578-011 D427-659-011 D315-670-011 and create labels per PPP K10008 CHG006(Bag Bluefiles separately)	
			(10) <i>KJ 07.17</i>
2.0	MUHMWB10	UHMW 1" Black	
		Comment: Qty.: 6.8250 sf(s)/Unit Total : 68.2500 sf(s) blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: M101627	
			<i>JK 06/07/23 16</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Note:(2) bearpaws for (1) Kit	
		1-Inspect material for defects or damage prior to machining	
		2-Machine as per Folio and Dwg D2432 Identify as D2432F	
		3-Deburr	<i>J.F 06/07/23</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #: Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F/9ML 06/07/24

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/07/25 X 10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.4166 f(s)/Unit Total : 4.1660 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion B24870<sup>58</sup> 20434x2

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block B26500d<sup>x50</sup> B27581x70

2 D2432F(ref only) Bearpaw 27871

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp B27080 ✓

\$ ST/FS

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:	Machine Or Operation:	Description :
10.0	D2529	Washer
		
<p>Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 12 D2529 Washer <u>B26485</u></p>		
11.0	D2732	Rubber Extrusion
		
<p>Comment: Qty.: 0.4166 f(s)/Unit Total : 4.1660 f(s) Pick: Packing Kit Qty Part Number Description Batch 6 D2732-050 Rubber Cushion <u>B26472</u></p>		
12.0	AN415A	Bolt
		
<p>Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 12 AN4-15A Bolt <u>M19185</u></p>		
13.0	AN417A	Bolt
		
<p>Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 12 AN4-17A Bolt <u>M19471</u></p>		
14.0	AN960JD416	Washer
		
<p>Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 24 AN960JD416 Washer <u>M101369</u></p>		

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

DQA: Date: 06/08/15

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

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Job Number:



Seq. #:	Machine Or Operation:	Description :
15.0	MS21042L4	Nut
<p>Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch</p>		
<p>12 MS21042L4 Nut (or -4) M19085 12B26/07/06 SL 06/07/26</p>		
16.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
17.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPPK10008 Location: New E</p>		
18.0	DC	DOCUMENT CONTROL
<p>Comment: DOCUMENT CONTROL Inspection Level 21</p>		

Job Completion



SL 06/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	27871
Description: Bearpaw	Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.058x45°	—			
B 5.500	+/-0.030	5.500	—			
C 0.200	+/-0.030	0.200	—			
D 0.25 x 45°	+/-0.030	0.250x45°	—			
E R0.250	+/-0.030	R0.250	—			
F 0.250	+/-0.010	0.243	—			
G 0.625	+/-0.030	0.610	—			
H 0.375	+/-0.010	0.382	—			
I 0.950	+0.030/0.010	0.954	—			
J 19.000	+/-0.030	19.000	—			
K 3.14	+/-0.030	3.128	—			
L 3.28	+/-0.030	3.310	—			
M Ø0.260	+0.005/-0.000	Ø0.260	—			
N Ø0.93	+/-0.030	Ø0.927	—			
O 0.30	+0.030/-0.000	0.305	—			
P 23.750	+/-0.030	23.750	—			
Q 7.375	+/-0.030	7.375	—			
R 4.250	+/-0.010	4.250	—			
S 2.000	+/-0.030	2.000	—			
T 9.000	+/-0.010	9.000	—			
U 9.000	+/-0.010	9.000	—			
V 0.375	+/-0.010	0.382	—			

Measured by:	<i>ml</i>	Audited by:	<i>En</i>	Prototype Approval:	N/A
Date:	06/07/24	Date:	06/07/24	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF <i>xx</i> <i>xx</i>

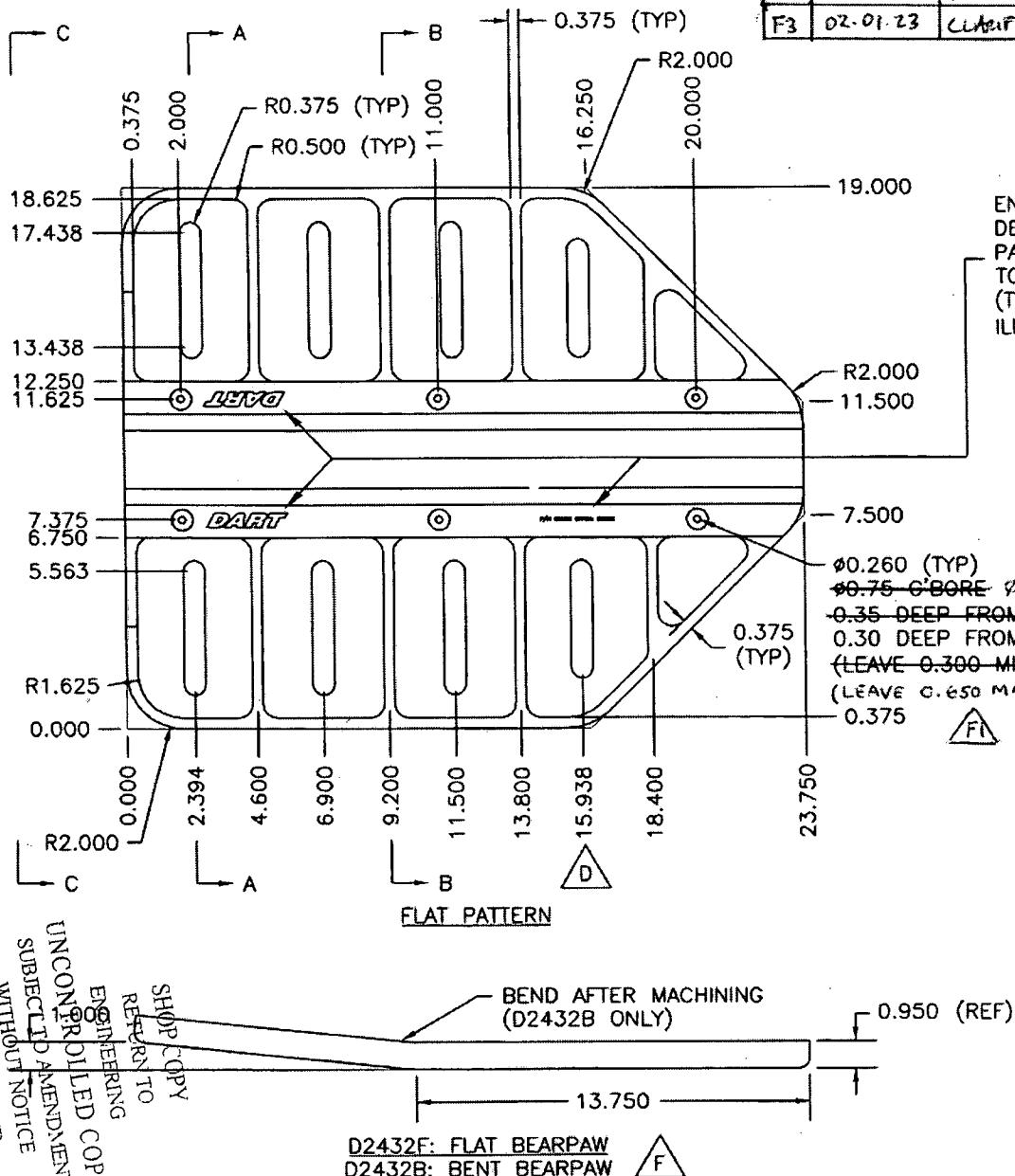


DESIGN <b>KE</b>		DRAWN BY <b>KE</b>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>MJ</b>	APPROVED <b>DS</b>	DRAWING NO. D24-32	REV. F	SHEET 1 OF 2
DATE 10/10/00	TIME 10:00		SCALE 1:100	

**RELEASED**

F1	99-03-03	ADD DEO 9143
F2	01-03-28	Φ0.93 WAS Φ0.75 <del>RF</del>
F3	02-01-23	CLARIFY CORE DIMS <del>OF RF</del>

ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)



BEND AFTER MACHINING  
(D2432B ONLY)

0.950 (REF)

13.750

D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW F

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

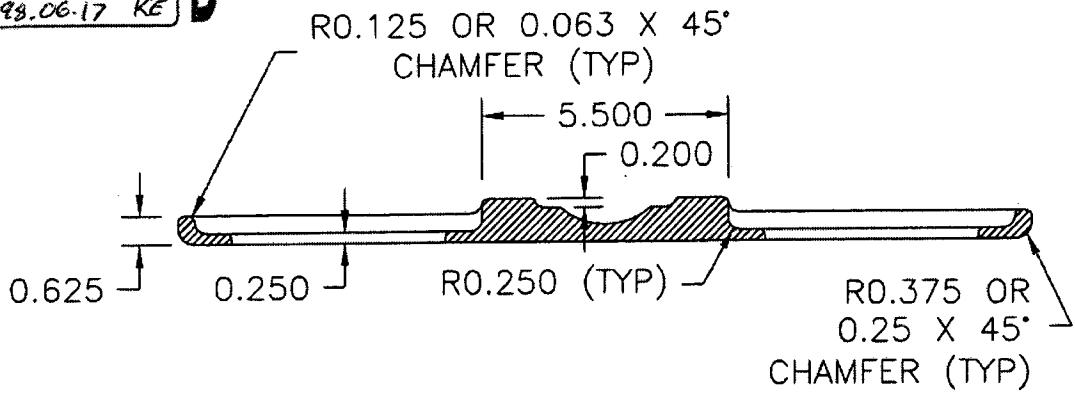
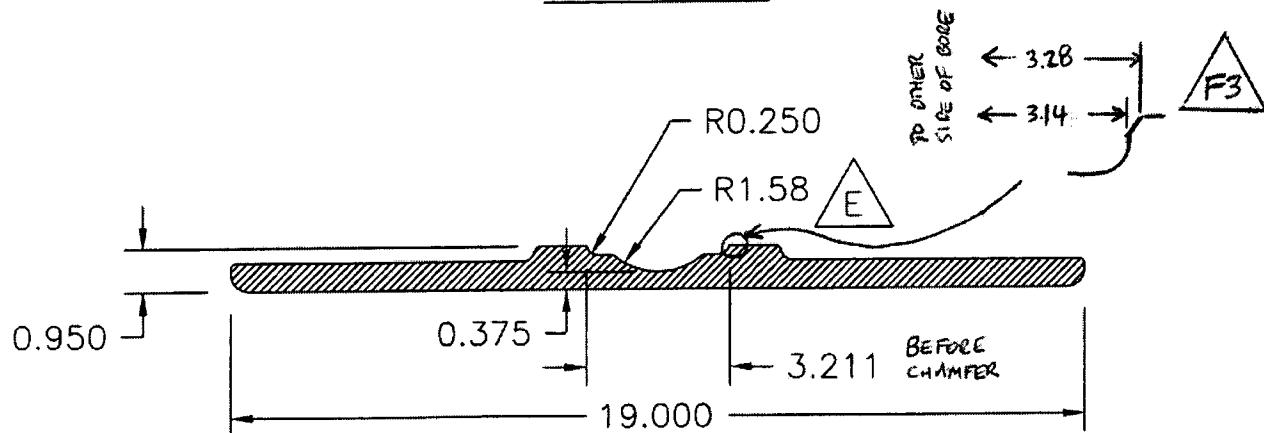
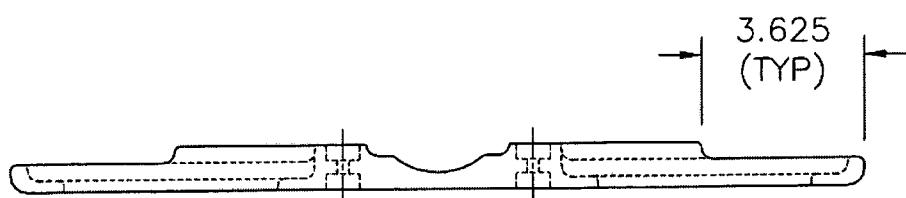
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~~CONTROLLED COPY~~  
~~JNCON PRO TROLLED AMENDMENT~~  
~~SUBJECT TO NOTICE~~  
~~WITHOUT ORDER.~~

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MW</i>	APPROVED <i>JS</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW	SCALE 1:4	

**RELEASED**

98.06.17 KE

SECTION A-ASECTION B-BSECTION C-C

SHOP COPY  
RETURN TO  
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WORK ORDER  
NO. 27871